

split

Work Order ID 91188 -2

October-03-12 2:31:03 PM

91188

Page 1

Item ID: D3873-1

Revision ID:

Item Name: Bushing

Start Date: 03/10/2012 Start Qty: 600.00

Required Date: 05/12/2012 Req'd Qty: 600.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: ML3

Date: 12-10-03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3873

C

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

1-TURN AS PER FOLIO FA806 & DWG D3873 ,
FOLIO REV: N/A
DWG REV: C

2-DEBURR AS REQUIRED

12/11/09

480

120

0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12/11/09

480

120

0

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Page 2

Item ID: D3873-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 03/10/2012 Start Qty: 600.00

600

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 600.00

600

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

2-11-9

480

4

DAS 04 9-8

130

Identify as per dwg & Stock Location: *db9*

0.00

130

Packaging

Memo

0.00

Packaging

12/11/12 (480)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/11/13

mf 12-11-12

Picklist Print

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Page 1

Work Order ID: 91188

Parent Item: D3873-1

Parent Item Name: Bushing

91188

D3873-1

Start Date: 03/10/2012

Required Date: 05/12/2012

Start Qty: 600.00

Required Qty: 600.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.625

Purchased

No

100

f

262.9432

0.06

37.89474

M303R0 625

**

37.333'

12/11/08

303 Round Bar 0.625"

Location

Loc Qty

Loc Code

MAT028

262.94321

118400

2

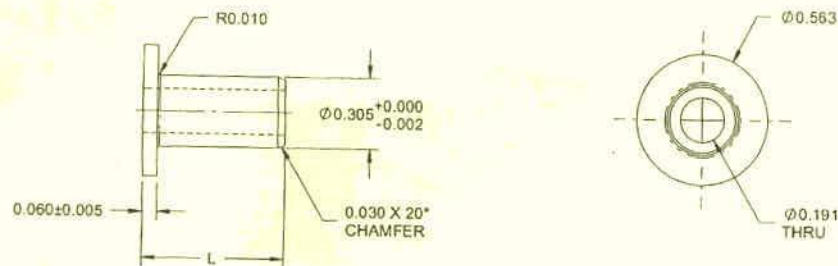
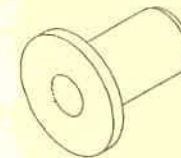
119009

104.94321

119766

156

37.333'



D3873-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007



NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

SHOP COPY
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SUBJECT TO AMPLIFICATION
WITHOUT NOTICE
WORK ORDER

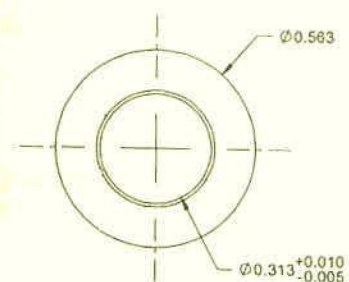
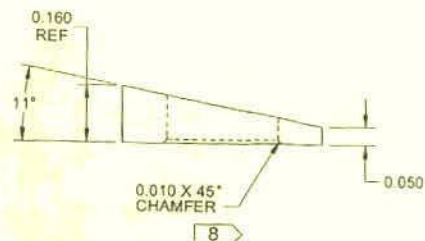
NO. 91188 MCT

12-10-03

RELEASED
2011-09-12

C	ADD D3873-3/5/7 (ZN B6-1 & B5-2)	RF	11.06.14
B	Ø0.563 WAS Ø0.63 (C3-1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	Q		
MFG. APPR.	E		
APPROVED	MA		
DE APPR.	MA	DRAWING NO. D3873 TITLE BUSHING REV. C SHEET 1 OF 2 SCALE NTS	
DATE	11.06.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

91188



C D3873-7 SPACER

RELEASED
2011-09-12

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RE	PORT HADLOCK, WA	
CHECKED	CH	DRAWING NO.	REV. C
MFG. APPR.	AL	D3873	SHEET 2 OF 2
APPROVED	AL	TITLE	SCALE
DE APPR.	AL	BUSHING	NTS
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